

Debrin 75

Work Order ID 85612

85612

Page 1

June-12-12 8:49:39 AM

Item ID: D3396-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Spacer

Start Date: 12/06/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MCS

Date: 12/06/12 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3396

Rev B

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn as per Folio FA514 and Dwg D3396Debur

DAS
14
2-89

12/07/29

38

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

DAS
14
2-89

12/07/29

38

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

29 12-7-29

38

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85612

85612

Page 2

June-12-12 8:49:39 AM

Item ID: D3396-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Spacer

Stop *NS2*

Start Date: 12/06/2012 Start Qty: 20.00 *20*

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 20.00 *20*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 Identify as per dwg & Stock Location: 044 0.00

130

Packaging Memo 0.00

Packaging

140 QC21- Final Inspection - Work Order Release 0.00

140

QC Memo 0.00

Quality Control

Handwritten signature and date 12/17/30

Handwritten date 12/17/30 and initials

Handwritten date 12/10/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

June-12-12 8:49:43 AM

Page 1

Work Order ID: 85612

85612

Parent Item: D3396-1

D3396-1

Parent Item Name: Spacer

Start Date: 12/06/2012

Required Date: 26/05/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A 05.02.23New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR0.750		Purchased	No			100	f	148.6450	0.0625	1.315789			

MDFI RINR0 750

**

Delrin Round Bar 0.75"

Location

Loc Qty

Loc Code

MAT055

148.645

116183

2.4

117273

1.555

117322

0.94

*120722

5.28

121783

138.47

1.8815 on 12/07/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

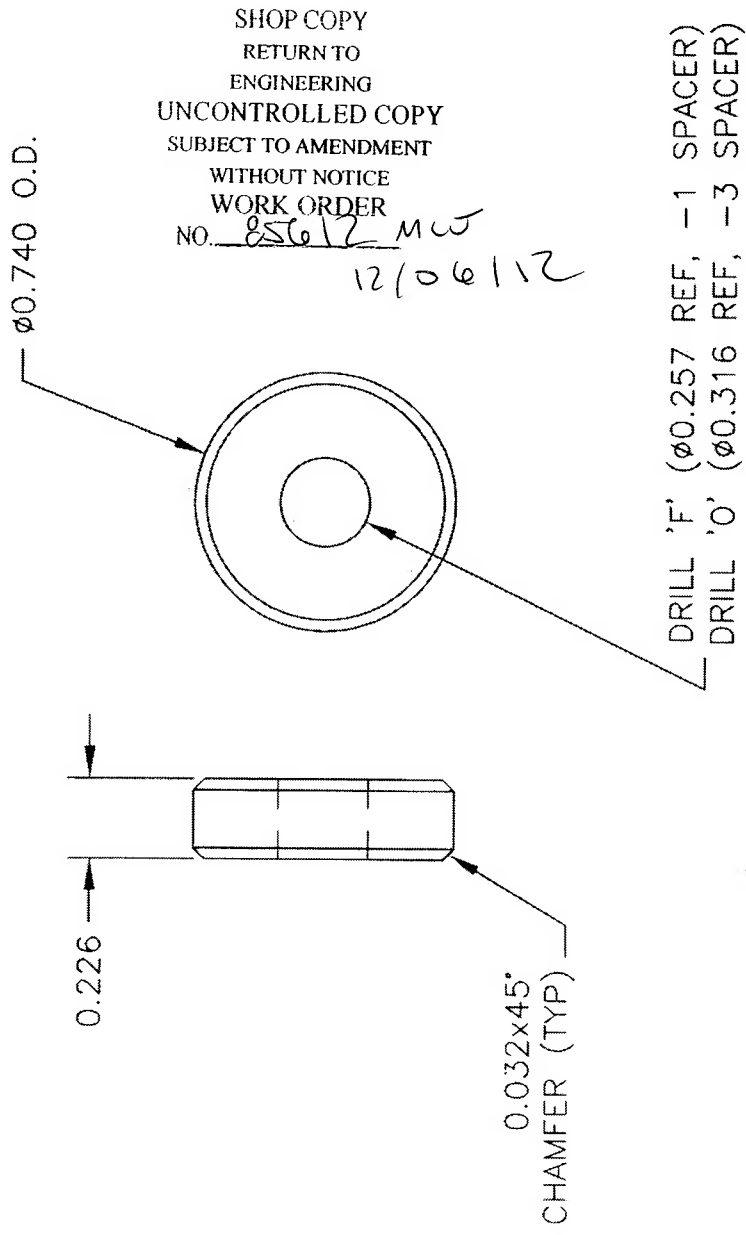
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NOTE: Date & initial all entries



DESIGN		DRAWN BY		DART AEROSPACE LTD	
CP		CP		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. B	
<i>[Signature]</i>	<i>[Signature]</i>	D3396		SHEET 1 OF 1	
DATE	TITLE		SCALE		
05.04.27	SPACER		2:1		
A	05.03.10		NEW ISSUE		
B	05.04.27		ADD -3		

05.09.06 *[Signature]*



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *85612 MW*
12/06/12

D3396-1/-3 SPACER

- 1) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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